Wednesday, 15/08/2007 4:00:44 PM

Linda Lacelle

Process Sheet

: CU-DAR001 Dart Helicopters Services Customer

Jot Number .: 33947 **Estimate Number**

: 11178

P.C. Number This Issue

MIA:

S.O. No. : X/A : 15/08/2007

Prsht Rev. : NC First Issue

: 32286

Checked & Approved By

Comment

New issue KJ/JLM : Est:A 04.08.24 Est Rev:B Now on Waterjet 06-11-02 JLM

SMALL /MED FAB

Drawing Name

Part Number **Drawing Number**

€:

: D32931 : D3293 REV A

: DOUBLER

: N/A **Project Number** : A

Drawing Revision :NA Material

Due Date : 22/08/2007

Qtv:

Each 30 Um:

Additional Product

Jot Number:



Seq. #:

Machine Or Operation:

Description: 2024-T3 .080 sheet

1.0

M2024T3S080

Comment: Qtv.:



1.9177 sf(s)/Unit Total: Material: 2024-T3 (QQ-A-250/4) 0.080" thick

(M2024T3S.080) Identify for D3293-1

Batch 104921

K

05-80-50

57.5316 sf(s)

m 104469

2.0 £ Eggs

WATER JE

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3293

Dwg Rev:_ Prog Rev:

US 07-08-20

2-Deburr if necessary

QC2 3.0

INSPECT PARTS AS THEY COME OFF MACHINE



BO7-08-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK





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W/O:			WC	ORK ORDER CHAN	NGES					
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			÷	•						
Part No		PAR #:	Fault Cate	gory:	NCR	: Yes (VO DQ		∑ Date: ᢕ	7109/11
						QA: N/	C Closed	d:	_ Date: _	
NCR:			WORK ORD	R NON-CONFORM	MANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section B				Verification Section C		Approval Chief Eng	Approval QC Inspector
DAIL	SIEF	Section A	Initial Action Desci Chief Eng Chief Eng		ion Sign & Date					
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NOTE: Date & initial all entries

Wednesday, 15/08/2007 4:00:44 PM Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: DOUBLER Mumber:** 33947 Part Number: D32931 ob kmber: Seq#: **Machine Or Operation:** Description: 5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 07-09-07 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Deburr Ç QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 7.0 HAND FINISHING HAND FINISHING RESOURCE # Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 POWDER COATING 8.0 POWDER COATING M 102316 Comment: POWDER COATING Powder Coat Black Sandtex (Ref. 4.3.5.7) as per QSI 005 4.3 9.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 10.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE W 87.09.11 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annessal	Annroyal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

QA: N/C Closed: ____ Date: ____



DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED M	APPROVED A	DRAWING NO.	REV. A
_#	#\-	D3293	SHEET 1 OF 1
DATE	1 3	TITLE	SCALE
04.06.28		DOUBLER	1:3
		100115	

04.06.28 NEW ISSUE QSI 018 UNLESS OTHERWISE NOTED 9.786 3.095 0.950 11.52 DIMENSIONS SHOWN FOR REFERENCE ONLY
MATERIAL: 2024—T3 (QQ—A—250/4) SHEET 0.080 THICK
MATERIAL: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER
DART QSI 005 4.3 1,874 FILE "D3293-A1.DWG" 0 o 0 **⊅62.**⊅ 82.4 (TYPICAL 9 PLACES SHOWN) o POWDER COAT BLACK DART QSI 005 4.3 TOLERANCES ARE PER DART 0 o 0 - 00.141 0 Ø0.128 (TYP 70 PLACES) ٥ O 10.10 0 (13 EQUAL SPACES) SEE DETAIL A -13.563 -11.07 o DETAIL SCALE o 0.312 R0.75 (TYP) R0.354 (TYP) RO.312 \$6.81 o 17.750 19,259 20.15 8.439 9.65

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DART AEROSPACE LTD	Work Order:	
Description: Doubler	Part Number:	D3293-1
Inspection Dwg: D3293 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.350	+/-0.010	.350	*			
0.650	+/-0.010	, (۵۲	X			
1.874	+/-0.010	1.877	¥			
Ø0.141	+0.005/-0.000	Ø .14S	×			
Ø0.128	+0.005/-0.000	Ø 131				
17.750	+/-0.010	17.750	*			
20.15	+/-0.030	20.15	1			
R0.350	+/-0.010	R 350	×			
R0.312	+/-0.010	R. 312	¥			

Measured by:	IR	Audited by:	en	Prototype Approval:	N/A
	07-08-30	Date:	174 ved 70	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.24	New Issue	KJ/JLM OKL	<i>\\\</i>